

Date: Monday, 16/06/2008 10:25:24 AM
User: Julie Lecocq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 39886
Estimate Number : 10010
P.O. Number :
This Issue : 16/06/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL / MED FAB
Previous Run : 39241
Written By :
Checked & Approved By : JUD 08.06.16
Comment : Est Rev: C Removed from 9 Digit 05-10-25 JLM
Est. C 06.07.21 waterjet EC

Drawing Name : LUG BRACKET
Part Number : D27353
Drawing Number : D2735 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 30/06/2008 Qty: 60 Um: Each

Additional Product

UNDER REVIEW

08.10.08

W 8.12.03

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1010S125 1010-1025 sheet .125



Comment: Qty.: 0.1733 sf(s)/Unit Total: 1.0395 sf(s)
1010-1025 sheet .125

batch: 108336 B 8-7-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D2735
Dwg Rev: C
Prog Rev: C

2-Deburr if necessary B 8-7-21

60

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

50012/21 60

8x 08/12/04 11
2/08/04 10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 39886

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/04 (X11)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Eric L ✓

SS 08/12/05 (X11)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



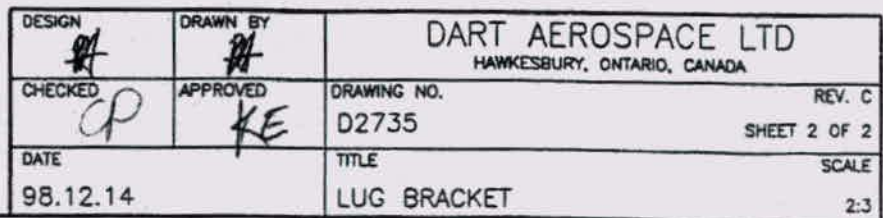
Comment: FINAL INSPECTION/W/O RELEASE

08/12/05 (X11)

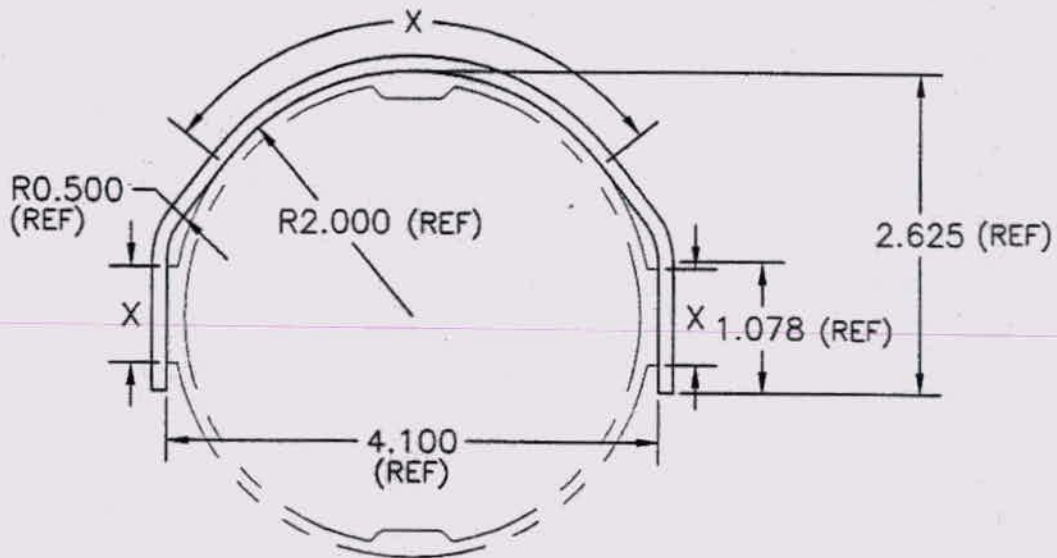
Job Completion



U 08.12.05



RELEASED
98.12.14 DS



D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39886

